

Date: Monday, 6/12/2006 3:36:33 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HI-SKI STEP LEG
Job Number	: 27501		
Estimate Number	: 11833		
P.O. Number	: N/A	Part Number	: D2499
This Issue	: 6/12/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2499 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
	Type : MACHINED PARTS	Material	: N/A
Written By	: <i>SEAN COMMENT Below</i>	Due Date	: 7/15/2006
Checked & Approved By	: <i>06.06.13</i>	Qty:	12 Um: Each
Comment	: Est. A00.06.26 Removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"
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Comment: Qty.: 1.9906 f(s)/Unit Total: 23.8871 f(s)

6061-T6 Bar 1.0" x 4.0"

6061-T6 1.00" Thick

Batch *M12315*

*J.F. 06/06/23*

*12*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 8.500" x 4.000"

*J.F. 06/06/23*

*12*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2499

Deburr

*mf 06/06/24*

*12*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*mf 06/06/24*

*12*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*Ep 06/06/26*

*2*

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Acid etch - Alkaline as per QSI 005 4.1*  
*a.m 06-06-27*  
*a.m 06-06-27*

*(P.T.O.)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-06-27	6	Alodine before powdercoat. Per maintenance. 2					 06-06-27	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:36:33 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-SKI STEP LEG

Job Number: 27501

Part Number: D2499

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 06 27 (12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57177

06/06/27 (12)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/27 (12)

Job Completion



06-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

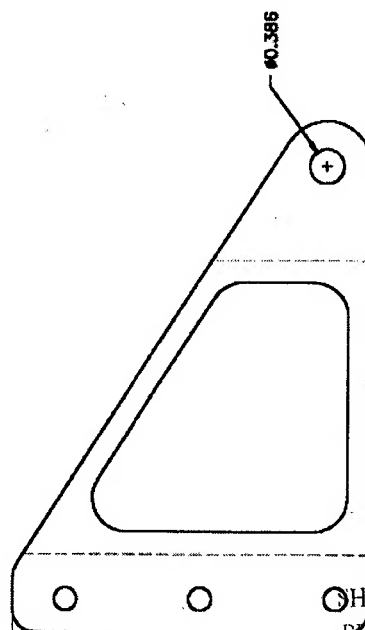
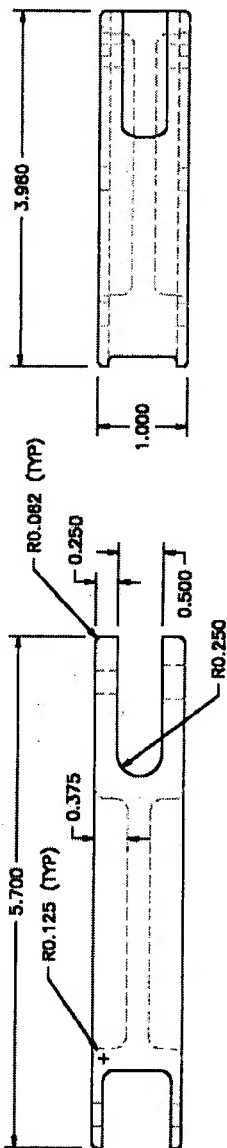
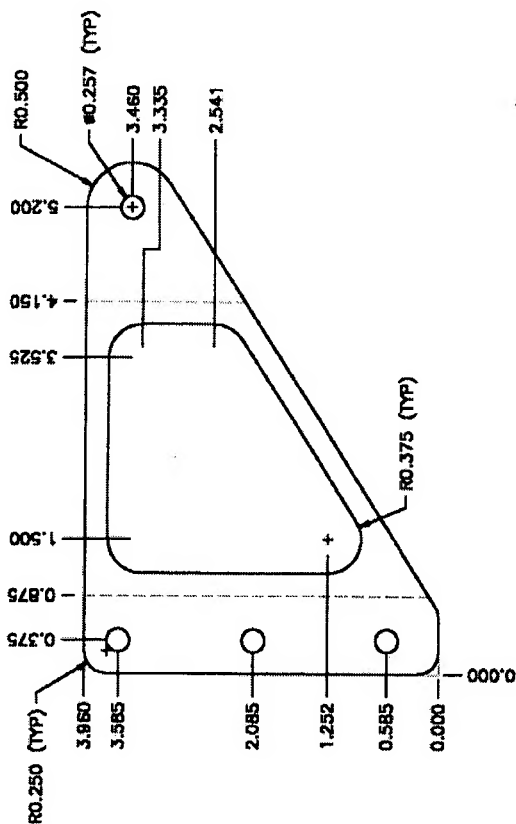
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>KH</i>	DRAWING NO. D2499	REV. B SHEET 1 OF 1
DATE 95:11:09		TITLE MOUNT	SCALE 1:2
B	95.12.06	CHANGE HOLE DIA TO .386	



MATERIAL: 6061-T6

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27501

DART AEROSPACE LTD		Work Order:	27501
Description: MOUNT		Part Number:	02499
Inspection Dwg: 02499, Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	±.005	0.584	—			
2.085	±.005	2.084	—			
3.585	±.005	3.581	—			
3.960	±.010	3.958	—			
6.375	±.005	6.374	—			
0.875	±.010	0.880	—			
4.150	±.010	4.144	—			
5.200	±.010	5.197	—			
5.700	±.010	5.697	—			
Ø 6.257	±.001 <sup>.005</sup>	Ø 6.258	—			
3.460	±.003	3.457	—			
R 0.125	±.010	R 0.125	—			
0.375	±.010	0.376	—			
0.250	±.010	0.253	—			
0.500	±.010	0.505	—			
1.000	±.010	1.007	—			
Ø 0.386	±.006 <sup>.001</sup>	Ø 0.388	—			

Measured by: <i>JML</i>	Audited by: <i>EA</i>	Prototype Approval: <i>N/A</i>
Date: 06/06/24	Date: 06/06/24	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	